

Work Order ID 59396

Thursday, June 03, 2010 12:40:17 PM

Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 6/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 106-03

Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr	Revision Nbr
D3914	A

100

Weld per dwg A/R S.S. rod Batch: M108775 0.00

Large Fab

Memo 0.00

10.06.21

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 make sure to place mesh correctly on lid, check with label plate before tacking mesh

110



QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo 0.00

Quality Control

10.06.22

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref.4.3.5.7) per QSI005 4.3

0.00

M 112588,

Powdercoat

Powder Coating

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 12.06

Oven Temperature: 300°

Finish Time: 12.30

S 110622

(1)

110622

140

Wing Walk as per dwg QSI005 4.4 Batch 114432 0.00

0.00

HandFinish

Hand Finishing

Memo

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

B# 114432

110623 (1)

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

EB 06/24 0

160



Packaging

Packaging

Identify as per dwg & Stock Location: G A

0.00

Memo

W/O 59394

0.00

EB 06/24 C

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/28 JF
CD 10/06/25

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Picklist Print

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Page 1

Work Order ID: 59396



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/3/2010

Required Date: 6/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	71.0000	2	2			

Mounting Bracket

Location Loc Qty Loc Cod

ST		22
	59121	22
WA		49
	46086	2
	51745	2
	57185	1
	58301	5
	58687	18
	59265	21

D3914-1

Manufactured No.

100 Each 2.000

Rib

Location Loc Qty Loc Cod

WA	2
59023	2

D3914-7

Manufactured No.

100 Each 2.0000

Rib

Location Loc Qty Loc Cod

WA	2
59022	2

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Required Date: 6/14/2010

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4016-3		Manufactured	No			100	Each	7.0000	3	3			

Hinge Half, Lid

Location	Loc Qty	Loc Code
----------	---------	----------

ST116	7	
-------	---	--

58243	7	
-------	---	--

D4018-5



Manufactured

No	100	Each	36.0000	9	
----	-----	------	---------	---	--

Rib

Location	Loc Qty	Loc Code
----------	---------	----------

WA	36	
----	----	--

58594	9	
-------	---	--

58669	18	
-------	----	--

59097	9	
-------	---	--

D4020-5



Manufactured

No	100	Each	0.0000	1	
----	-----	------	--------	---	--

Mesh (350 Basket Long, Lid)

D4021-3



Manufactured

No	100	Each	6.0000	1	
----	-----	------	--------	---	--

Data Plate

Location	Loc Qty	Loc Code
----------	---------	----------

WA	6	
----	---	--

56050	1	
-------	---	--

59054	5	
-------	---	--

D4035-041



Manufactured

No	100	Each	0.0000	1	
----	-----	------	--------	---	--

Lid Rib Assembly, Fwd (350 Basket)

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Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/3/2010

Required Date: 6/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4035-043 		Manufactured	No			100	Each	0.0000	1	1			
Lid Rib Assembly, Aft (350 Basket) 		Manufactured	No			140	Each	0.0000	1	1		10.06.10 B39102 > 2	
D2728-3 		Manufactured	No			140	Each	0.0000	1	1		E310/06/24	
Dart Logo label 		Manufactured	No			140	Each	11.0000	1	1		E310/06/24	
D4086-210 		Manufactured	No			140	Each	11.0000	1	1		E310/06/24	
Placard, Max Load 													

Location	Loc Qty	Loc Code
ST117	11	
58926	11	

B56978 (ix)

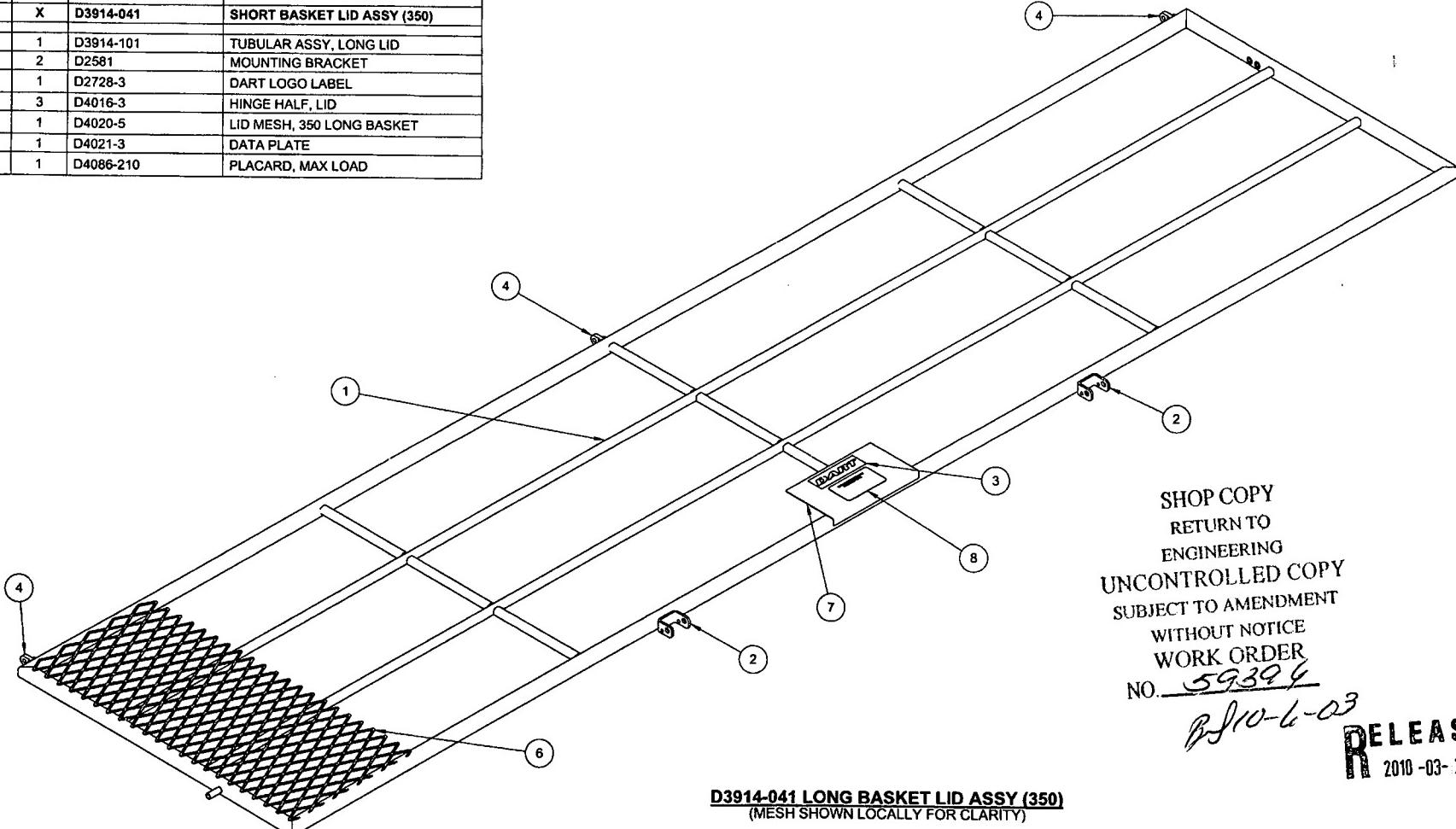
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ITEM	QTY	P/N	DESCRIPTION
	-041	X D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59394
B310-6-03

RELEASED
2010-03-22
W

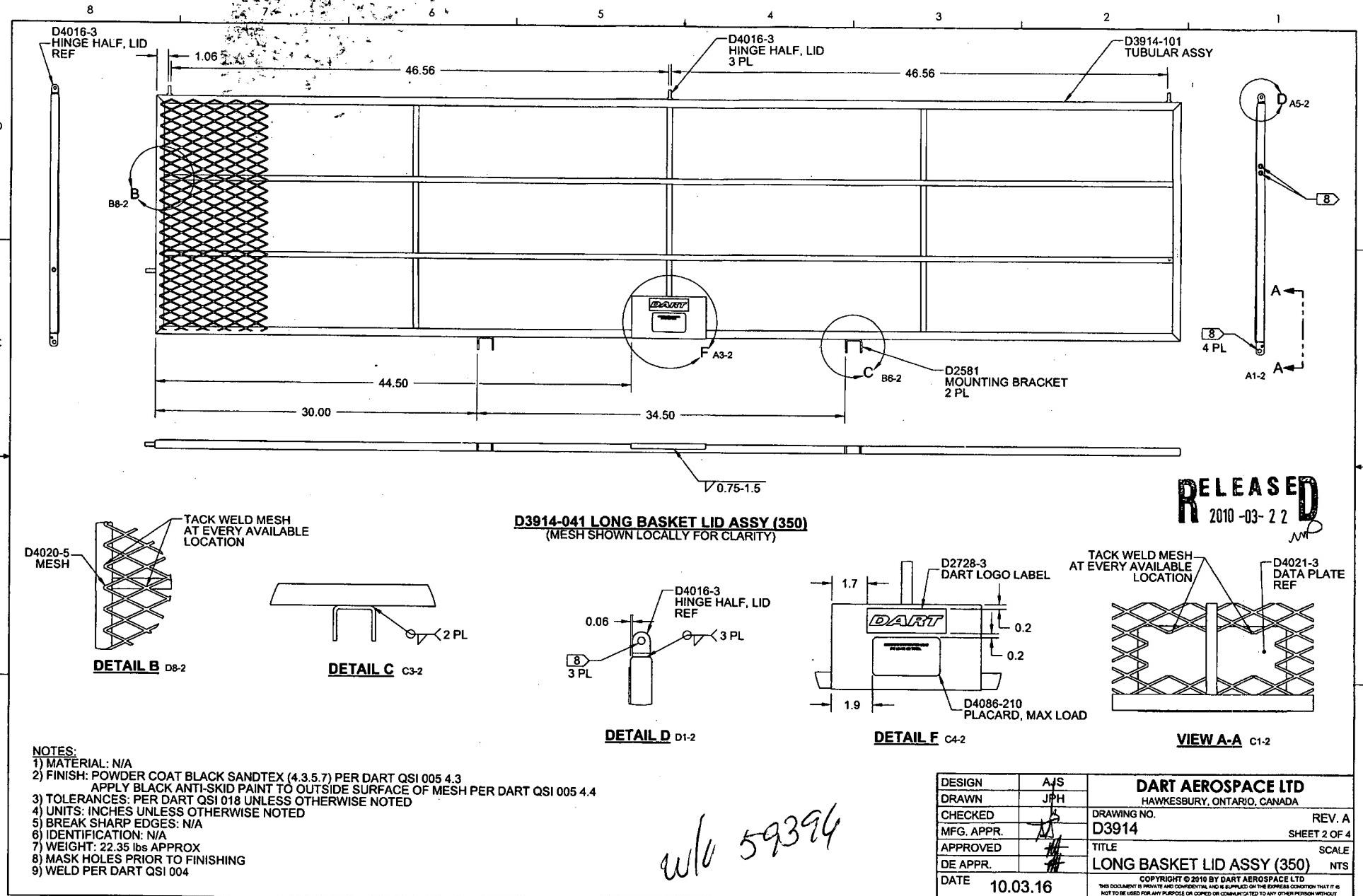
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REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>5</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>1</i>	D3914	SHEET 1 OF 4
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.	<i>#</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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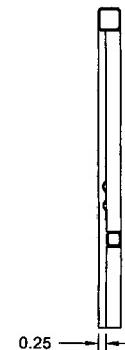
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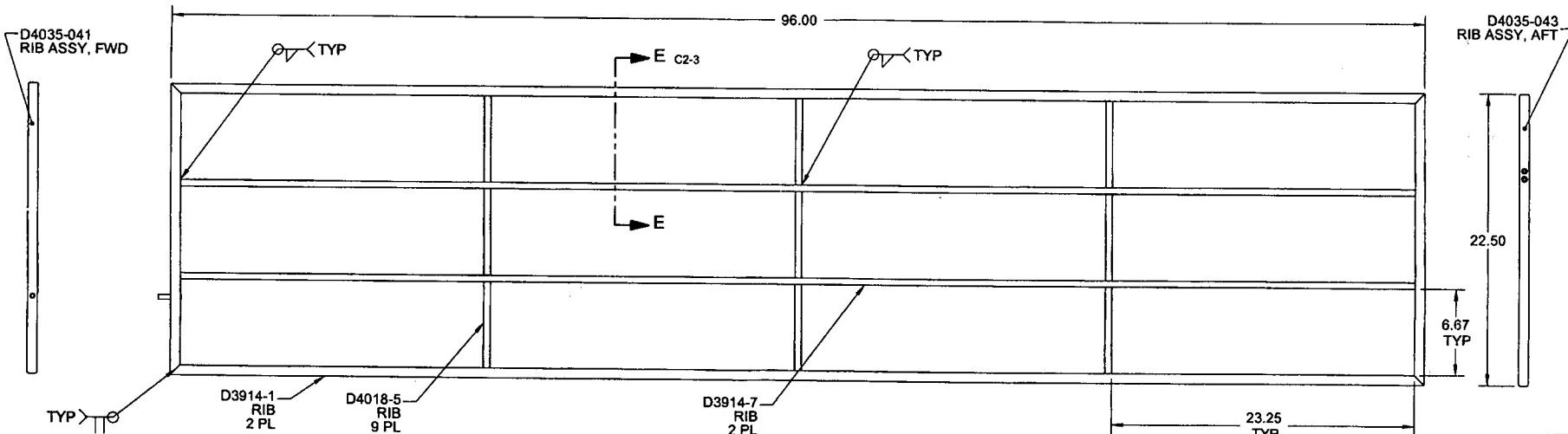
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED
2010-03-22
[Signature]

8 > D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 14.10 lbs
 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
 9) WELD PER DART QSI 004

w/o 59396

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350)	NTS
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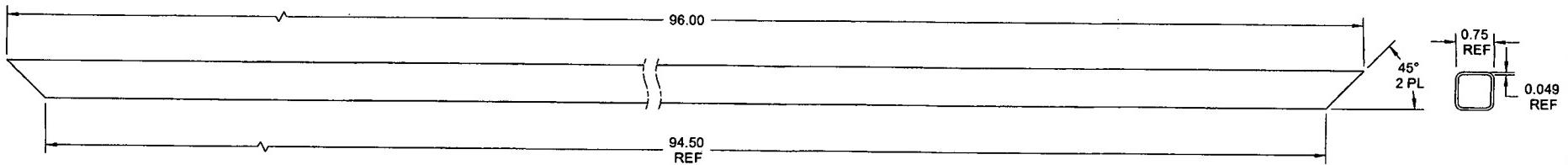
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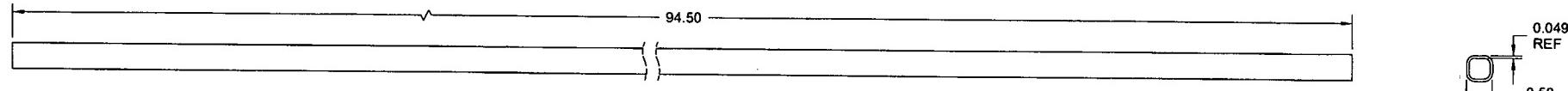
8 7 6 5 4 3 2 1

D



D3914-1 RIB

C



D3914-7 RIB

B

WLO 59396

RELEASED
2010-03-22
MWD

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	X	DRAWING NO.	
MFG. APPR.	X	REV. A	
APPROVED	X	D3914	
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